

Date: Tuesday, 10/2/2007 10:39:43 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	FWD MOUNTING LUG
Job Number	34934			
Estimate Number	10453			
P.O. Number			Part Number	D26162
This Issue	10/2/2007	S.O. No.	Drawing Number	D2616 REV D3
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type	Drawing Revision	D3
Previous Run	27886		Material	
Written By			Due Date	10/15/2007
Checked & Approved By	<i>10/07/02</i>			
Comment	Est Rev C 00.06.22 Removed P/O for powder coat EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"	
		Comment: Qty.: 0.1749 f(s)/Unit Total : 3.4986 f(s) Material: 6061-T6 QQ-A-200/8 2" X 1" Bar Batch <i>M106563</i>	<i>Amf 08/02/02</i> 10
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.000" long +0.030" -0.000"	<i>Amf 08/02/02</i> 10
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	<i>PTO -></i>
		1-Machine as per folio D2616-2 & DWG D2616	
		2-Tumble & Deburr	<i>J.L. 08/02/11</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>J.L. 08/02/11</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>J.L. 08/02/11</i> (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ616-2 PAR #: N/A Fault Category: Prod / Machines ^{Part} NCR: Yes No DQA: SD Date: 08/03/06
 QA: N/C Closed: SD Date: 08/03/06

NCR: <u>34934</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/02/10</u>	<u>3</u>	- 2 part Ø.8115 -812 are are ø being opened at .8135 by .811 reamer	<u>08/04/10</u>	- scrap + replace(Qty 82) B# 106563	<u>SD</u> <u>08/02/10</u>	<u>SD</u> <u>08/02/11</u>	<u>SD</u> <u>08/04/10</u>	<u>SD</u> <u>08/02/11</u>

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FWD MOUNTING LUG	
Job Number: 34934		Part Number: D26162	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  10-	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		BR 08-02-12	
7.0	POWDER COATING 	POWDER COATING M106442  10X	
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 Note: Mask large hole		m-l 08/02/13	
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION JY 	
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08-02-13 10	
9.0	D2611 	Bearing 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2611 Bearing B3602910X B 37888(10X) 50		8/2/14	
10.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Coat bearing in light oil 2-Press Bearing in D2616-2 3-Stack as per Dwg D2616 using DT8019 4- Touch up paint if required		X10 ml 09/03/03	
11.0	QC5 	INSPECT WORK TO CURRENT STEP  5 08/03/03 (410)	
Comment: INSPECT WORK TO CURRENT STEP			
12.0	PACKAGING 1 	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 468		8/3/3 36 (10X)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:39:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 34934

Part Number: D26162

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



~2008/3/04

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34934
Description: Mounting Lug	Part Number:	D2616-2
Inspection Dwg: D2616 Rev: D3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L.
Date:	08/02/10

Audited by:	<u>JF</u>
Date:	<u>08/02/10</u>

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	<i>[Signature]</i>

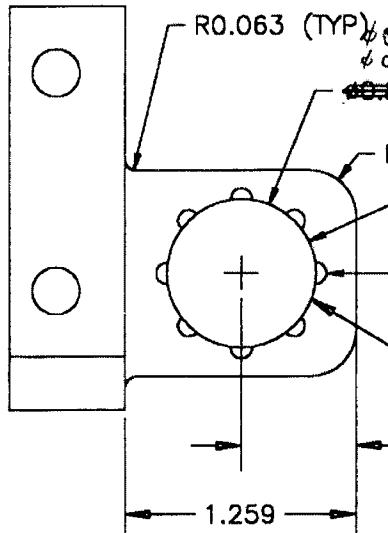


1 COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
	BW	D2616	SHEET 1 OF 1
DATE		TITLE	SCALE
97.07.31		FWD MOUNT LUG	1:1

DI	99.12.16	STAKE 4 PLACES INSTEAD OF 8 PLACES SIDE	A	96.10.20	ORIGINAL ISSUE
D2	00.11.21	CHG. HOLE TOL. PER NCR 449.	B	97.05.06	RE-DESIGN
D3	02.04.70	ADD STAKING NOTE PER CAR 107	C	97.06.04	REMOVE D2616-3
			D	97.07.31	D2611 WAS CBA-6-B2

VIEW A-A



MATERIAL: 6061-T6 QQ-A-200/8
BREAK ALL SHARP CORNERS 0.010 TO 0.020
UNLESS OTHERWISE NOTED
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
PRIME PER QSI 005 4.2
OR PRIME, PAINT PER CUSTOMER SPEC
PER QSI 005 4.2

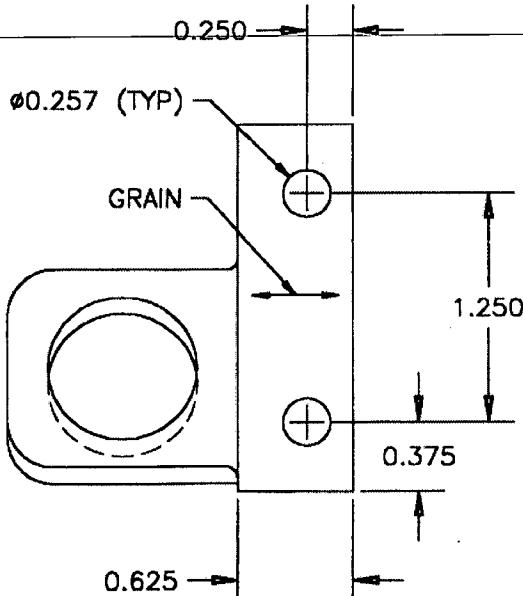
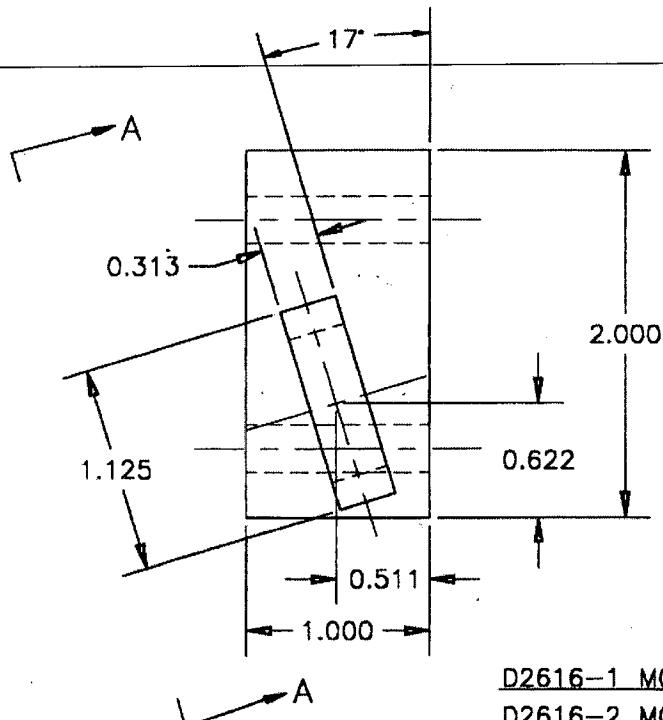
RELEASED
970731 BW

PRESS FIT BEARING D2611
AFTER PRIME

STAKE BEARING 4 PLACES
EACH SIDE

MASK BEARING PRIOR TO PAINT
LEAVE EDGES SHARP

STAKING NOTE:
D2611 BEARING MUST BE STAKED TO PREVENT
TRANSLATION BUT TO STILL ALLOW ROTATION
USING DT8089, TOUCH UP PAINT AFTER STAKING.



D2616-1 MOUNTING LUG SHOWN
D2616-2 MOUNTING LUG OPPOSITE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34934

